

Work Order ID 148724

Wednesday, July 06, 2016 8:44:39 AM

148724

Page 1

Item ID: D119-796-151

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 7/15/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/11/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: **DAS**
21
9-89 Date: **JUL 11 2016**

Tooling:

Date:

Run Start

NR1

QC: Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D119-796-151	D								
110	Document Control	0.00							
110									
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D119-796-151 chg 004								
120	Pick Kit	0.00							
120	Packaging								
Packaging	Memo	0.00							
Packaging									
130	Crosstubes	0.00							
130									
Crosstubes	Memo	0.11							
Crosstubes	1- Install step and clamp with the proper position per dwg D119-796-151								
	Torque all clamps to 50 IN-LBS max.								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER :			

Work Order ID 148724

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Page 2

Item ID: D119-796-151 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: FWD Crosstube Installation with Step (no hardware)
 Start Date: 7/15/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/11/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
140									
QC	Memo	0.00							SEP 07 2016
Quality Control	***RE-CHECK TORQUE ON CLAMP AS PER DWG.***								
	***VERIFY BY <u>148724</u> ^{DAS 38 9-89} BATCH # TO MATCH W/O								
	***VERIFY BY <u>148724</u> ^{DAS 38 9-89} PART # TO MATCH								
	W/O <u>148724</u>								
150	Packaging	0.00							DAS 41 9-89
150									
Packaging	Memo	0.00							16-9-6
Packaging	Identify and pack for shipping as per PPP D119-796-151								
	<u>AU1</u>								
160	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89
160									SEP 07 2016
QC	Memo	0.02							
Quality Control									DAS 21 9-89

SEP 07 2016

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Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation		Disposition				
SAC EC SAC		SAC QC SAC EC SAC			Completed By	
					Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY				
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
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Picklist Print

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148724

Parent Item: D119-796-151

D119-796-151

Parent Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 7/15/2016

Required Date: 8/11/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.11.19 AS PER REV.C DD VERF:JLM IPP REV:C
14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:D 15-02-11
AS PER REV D JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D119-796-141		Manufactured	No				Each	0.0000		1			
D119-796-141					148313				**	1		DAS 41 9-89	16-8-25
FWD Crosstube Installation without Step (no hardware)													
D5123-3		Manufactured	No				Each	116.0000		4			
D5123-3									**			DAS 41 9-89	16-8-25
Clamp Cushion													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG054			12						
				147939			12						
				LG055			104						
				145850			32						
				145851			36						
				146879			36			4			
D5149-041		Manufactured	No				Each	4.0000		2			
D5149-041									**			DAS 41 9-89	16-9-6
Fwd Step Base Assembly													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				LG055			4						
				143466			4						

DQA: _____ Date: _____



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Picklist Print

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Work Order ID: 148724

148724

Parent Item: D119-796-151

D119-796-151

Parent Item Name: FWD Crosstube Installation with Step (no hardware)

Start Date: 7/15/2016

Required Date: 8/11/2016

Start Qty: 1.00

Required Qty: 1.00

MS21920-22

Purchased

No

Each

59.0000

4

DAS

MS21920-22

41

9-89

16-8-25

Clamp

4

Location

Loc Qty

Loc Code

LG050

55

M133769

55

Return2016

4

125487

4

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

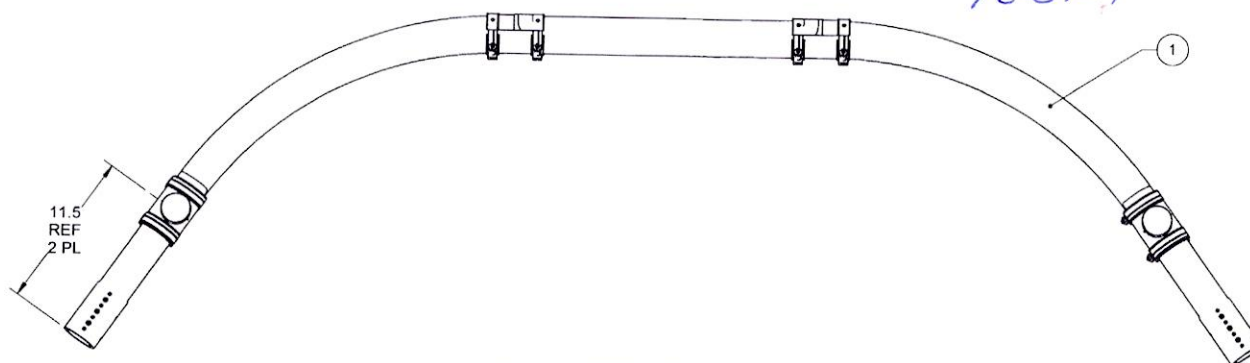
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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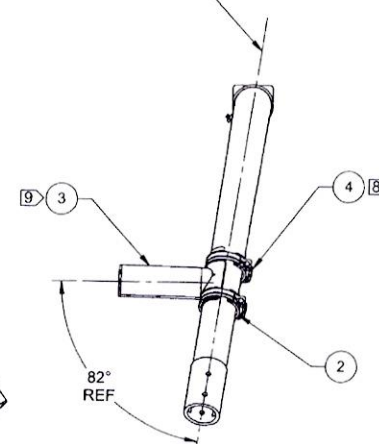
ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-151	XTUBE ASSY (AW119 MKII FWD)
1	1	D119-796-141	XTUBE ASSY (AW119 MKII FWD)
2	4	D5123-3	CUSHION
3	2	D5149-041	FWD STEP ASSEMBLY
4	4	MS21920-22	CLAMP

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148724 MJS
16-07-11



D119-796-151 XTUBE ASSY (AW119 MKII FWD)

**D119-796-141 XTUBE
BENDING PLANE**



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 19.87 lbs
- 8) TORQUE MS21920-22 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

RELEASED

2015 FEB 09

ECN 15-516

D	D5123-3 CLAMP CUSHION WAS D5123-9 CLAMP CUSHION, MS21920-22 WAS -24.	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D5149-043 WAS D5149-041, AN4C6A WAS AN4C10A, D2274 WAS D5153-1	AP	14.11.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP		
DRAWN	AP		
CHECKED	DB		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	15.01.19		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D119-796-151

REV. D
SHEET 1 OF 1

TITLE
XTUBE ASSY (AW119 MKII FWD) NTS

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